

Work Order ID 52964

October 19, 2009 2:23:48 PM



Page 1

Item ID: D3262-041
Revision ID: C
Item Name: Canister Assembly

Accept



Setup Start



Stop



Start Date: 10/19/09 Start Qty: 5.00 *2.00*
Required Date: 10/26/09 Req'd Qty: 5.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: *[Signature]*
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3262

Rev A2

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld canister assembly as per Dwg D3262 using DT8739 to align
fillings (Pick: Qty Part Number Description
Batch: A/R Aluminum Rod *M112860*

(2)

09/11/17

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

Pressure test as per Dwg D3262

BE (2) 09/11/17

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2/8 07/11/17

(2) f

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
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Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

=> M 09/11/17

(XZ) Ø

HandFinish

Memo

0.00

Hand Finishing

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

11/12/10

=> M 09/11/17

(XZ) Ø

Powdercoat

Memo

0.00

Powder Coating

2-Ensure to mask threads

START TIME:

7:30AM

OVEN TEMPERATURE:

8:00AM FINISH

TIME:

3209=

150

QC3- Inspect Part Finish

0.00

BK 09-11-18

(2)

QC

Memo

0.00

Quality Control

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Start Date: 10/19/09 Start Qty: 5.00
Required Date: 10/26/09 Req'd Qty: 5.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 144

0.00



Packaging

Memo

0.00

Packaging

9/11/09 2054

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/09

u 09.11.09

Picklist Print

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Page 1

Work Order ID: 52964

Parent Item: D3262-041RevC

Parent Item Name: Canister Assembly






Comments:

Start Date: 10/19/09

Required Date: 10/26/09

Start Qty: 5.00 *2.00*

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3262-1RevA2		Manufactured	No				Each	0.0000	5.0000			
									 *B53504		<i>2</i>	<i>10/11/09</i>
Tube												
D3262-3RevA2		Manufactured	No				Each	0.0000	10.0000			
									 *B41823		<i>2</i>	<i>10/11/09</i>
Cap									 *B43256		<i>2</i>	<i>10/11/09</i>

150

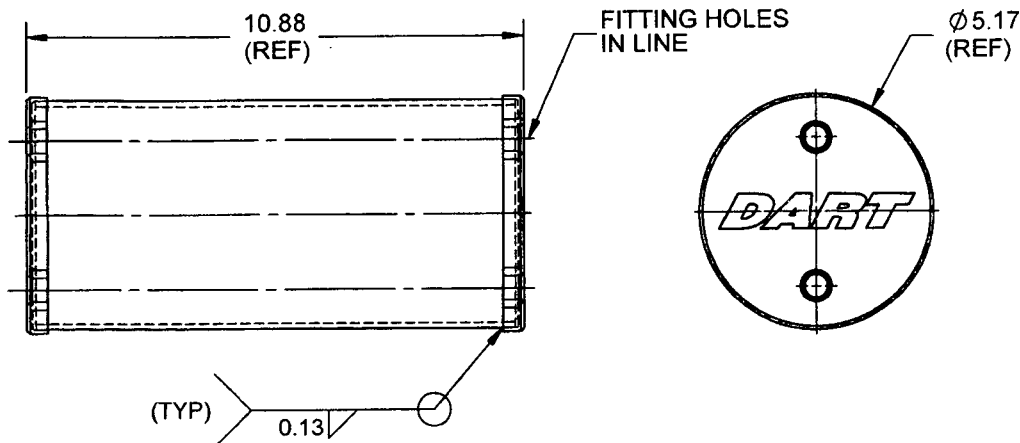
DART

DESIGN <i>PH</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D3262	REV. C SHEET 1 OF 2
DATE 06.08.31		TITLE FUEL PURGE CANISTER SCALE 1:4	
REV	DATE	DESCRIPTION	
A	04.05.06	FIRST ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	
C	06.08.31	Ø 5.165 WAS Ø 5.190	

RELEASED

06.09.19 *H*

w/p 52964

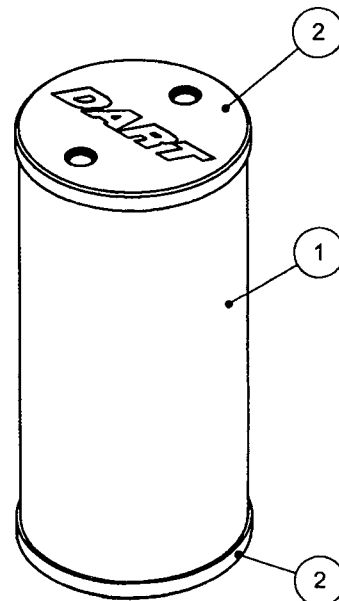


D3262-041 CANISTER ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3362-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

NOTES:

- 1) WELD PER DART QSI 004
- 2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART
QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER

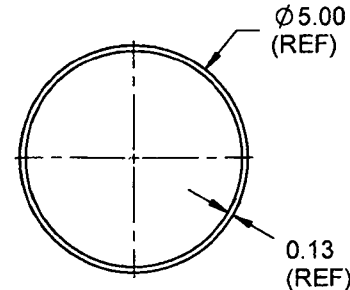
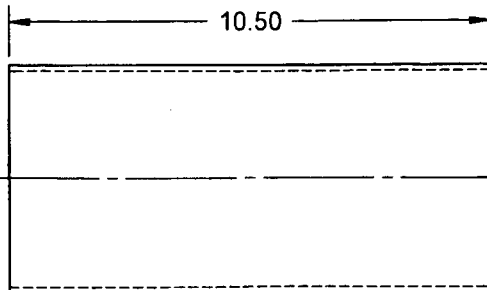


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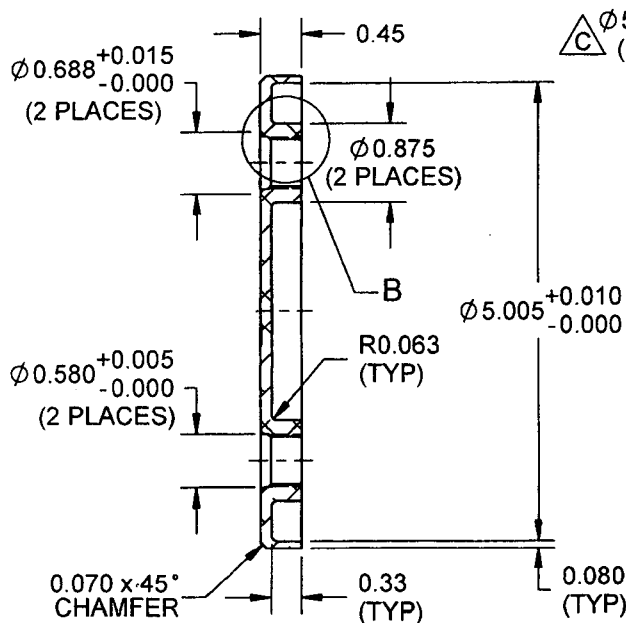
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DART

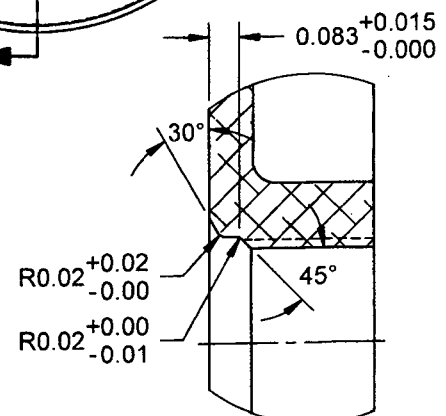
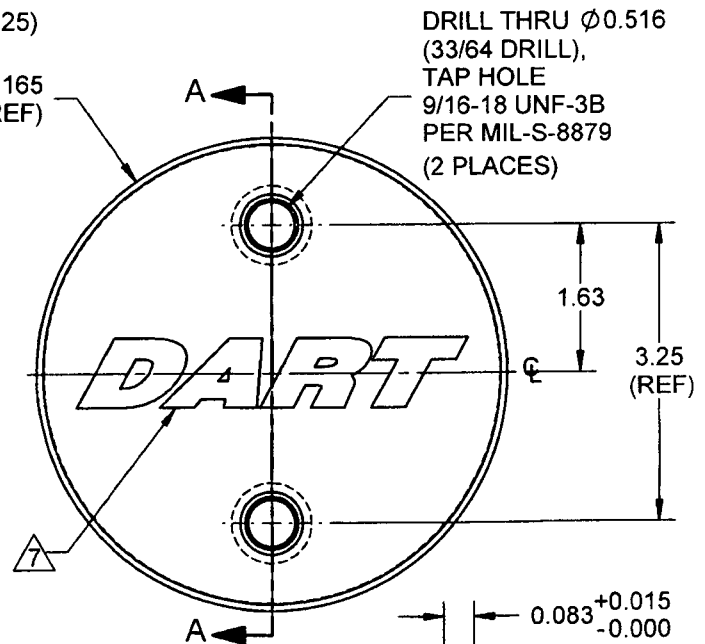
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3262	REV. C SHEET 2 OF 2
DATE 06.08.31		TITLE FUEL PURGE CANISTER	SCALE 1:4

**D3262-1 TUBE**

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR
QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T5.000W.125)



SECTION A-A
SCALE 1:2



DETAIL B
SCALE 2:1

D3262-3 CAP

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)

NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE
- 7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)

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